

5/20

DART AEROSPACE LTD	Work Order:	23050
Description: Panel	Part Number:	D3330-3
Dwg: D3330 Rev. A PAGE 4 Ref: RF 05.01.17	Qty:	15
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RF	05.04.15	15
2	PG	Issue P/O: 7007923 Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3330 Possible Supplier: Industrial Laser Material release note is required			
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CJ	05.05.15	15
4	QC6	Inspect dimensions as per Dwg D3330 OR D3330-3 TI TEMPLATE	J	05.05.18	15
5	GA	Deburr	CPL	05.05.18	15
6	GB	Form as per Dwg D3330			
7	QC5	Inspect work to Step 6	J	05.05.18	15
8	ST	Identify and Stock	CPL	05.05.18	15
9	AC	Cost / part: 11.72	S42	05.05.19	15
10	DC	Close W/O 11.53 Inspect Level 21	RF	05.05.24	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	RF

RELEASED
11/05/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

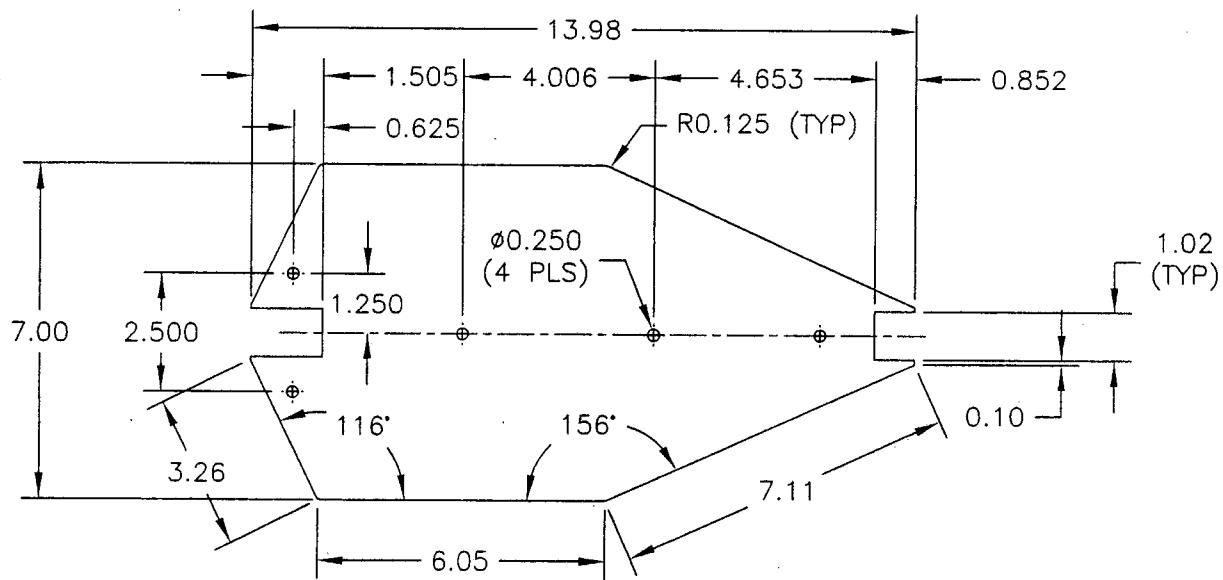
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**PRELIMINARY ISSUE**

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED	DRAWING NO. D3330
DATE 05.02.26		REV. B SHEET 4 OF 9 TITLE FRAME WELDMENT SCALE 1:4

**D3330-3 PLATE**

SHOP COPY

RETURN TO
ENGINEERING

TELECOPILED COPY

AMENDMENT
NOTICE

ORDER

NO. 23050**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No	:	0023050	Department Code:	
Project Name	:	D3330-3	Burden Flags	: NNNNNNN
Project For	:	WK520	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3330-3	Invoice Number	:
Description	:	Panel	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	15	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	04-12-05	Est Mark Up	: 0.000%
Est Finish Date	:	05-15-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Burden	:	0.00	0.00	0.00	0.00
<hr/>		<hr/>	<hr/>	<hr/>	<hr/>
Total Cost	:	0.00	0.00	0.00	0.00
Mark up	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00



BHP New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephone: (09) 3758 999 Auckland
(09) 2358 099 Waikuku
Fax: (09) 3758 959 Telex: 24936

TEST CERTIFICATE

Ref 985/2301

CUSTOMER		Wilkinson													SPECIFICATION ASTMA569						CERTIFICATE No TC027066			
CUSTOMER O/N		90-31N-067													PRODUCT HOT ROLLED PICKLED & OILED						PAGE 1 of 1			
MILL O/		256321													DIMENSIONS 0.119" x 48" x Coil						DATE 22 November 2000			
CHEMICAL COMPOSITION PERCENT																								
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS	r ()	LENGTH (feet)
		x100			x1000						x10000		x100											
HP-720792-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						820
HP-720793-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						827
HP-720794-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						817
HP-720795-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						830
HP-720796-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						887
HP-720797-00	602612	6	TR	21	9	18	12	18	22	4	6	1						Good						810

11 GA

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 √ So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45) / 4	IMPACT TEST (A) x 10mm x 10mm (B)=7.5mm x	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Batish Misra
QC METALLURGIST